

Date: Monday, 4/10/2006 11:14:55 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 26624		
Estimate Number	: 10700		
P.O. Number	: N/A	Part Number	: D34291
This Issue	: 4/10/2006 S.O. No. : N/A	Drawing Number	: D3429 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 24252	Material	: N/A
Written By	: <u>SEE 1A COMMENT BELOW</u>	Due Date	: 4/17/2006 Qty: 30 Um: Each
Checked & Approved By	: <u>06.04.10</u>		
Comment	: Est: A 05.10.04 New Issue KJ/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 984

Email or ship DXF file to vendor

Laser Cut D3429-1 Flat pattern as per Dwg D3429

Material release note required

C 206/04/10 (30)

2.0	D34291F	WEARPAD
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Comment: Qty.: 1.0000 U(s)/Unit Total : 30.0000 U(s)
 WEARPAD

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

C 206/04/20 32

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per template D3429-1T1

06.04.23 (32)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3429 using Jigs DT8261 and DT8326. Identify as D3429-1 54P 06.05.03

Form Joggle as per Dwg D3429 on brake using Jig DT8158 54D 06.05.03

(32)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 12 Date: 06/05/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/10/2006 11:14:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 26624

Part Number: D34291

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch M100 237.

A/R 560 Hardcoat

Weld hardcoat as per Dwg D3429

M.F. 06-05-04 (32)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AA 06/05/04 (32)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AA 06/05/04 (32)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 06 05 10 (32)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL
G.M.

06-05-11

(32)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 9

DL

06/05/11

(32)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/12 (32)

Job Completion



h 06/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

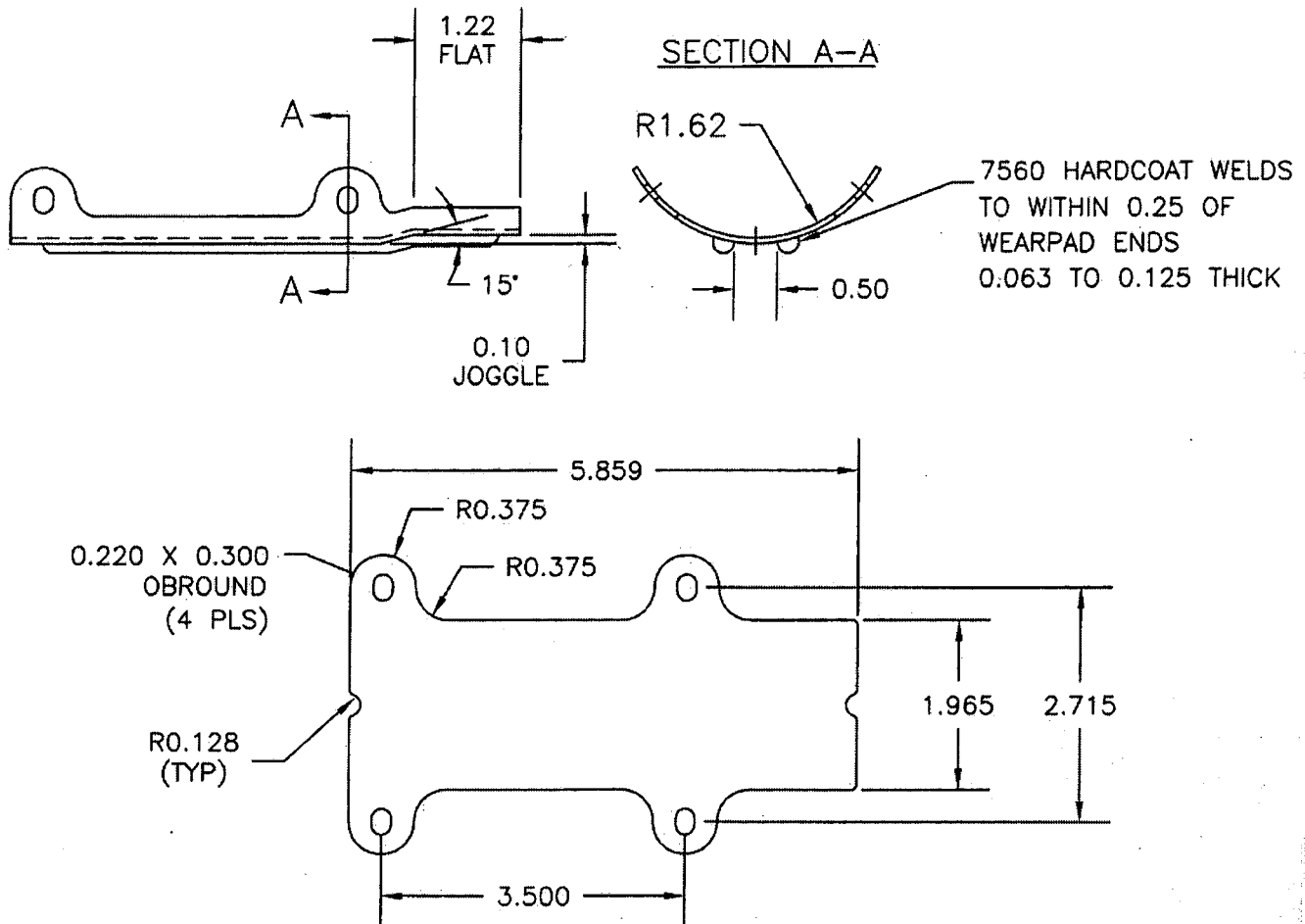
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN		DRAWN BY		DART AEROSPACE USA, INC.	
CP		CP		PORT HADLOCK, WA	
CHECKED		APPROVED		DRAWING NO.	REV. A
				D3429	SHEET 1 OF 1
DATE			TITLE		SCALE
05.04.18			WEARPAD		1:2
A	05.04.18		NEW ISSUE		

RELEASED
05.09.06**D3429-1 WEARPAD**

- 1) BREAK ALL SHARP CORNERS 0.063 MAX
- 2) MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
- 3) FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 26624

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TEST CERTIFICATE

Ref: 5740/25194

Released 1/12/2005

CUSTOMER		Waka		SPECIFICATION														ASTMA1008 CS Type A														CERTIFICATE No		TCL22432	
CUSTOMER ON		90-21N-963		PRODUCT														CRA WIDE COIL														PAGE		1 of 1	
MILL ON		50766		DIMENSIONS														0.853" x 48" x Coils														DATE		29 November 2005	
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT																		MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)															
		C	SI	Mn	P	S	CU	NI	CR	MO	V	NO	TI	AL	B	N2	CE ()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH											
		x100				x1000														x10000		x100		180°			GL"	HRB	()	(mm)					
R9-470713-00	645502	6	1	20	14	21	11	17	21	2	6	1	1					Good				57		1532											
R9-470714-00	645502	6	1	20	14	21	11	17	21	2	6	1	1					Good				57		1444											
R9-470715-00	645530	6	1	20	13	21	12	17	22	2	5	1	1					Good				53		1538											
R9-470716-00	645530	6	1	20	13	21	12	17	22	2	5	1	1					Good				53		1499											
R9-470717-00	645530	6	1	20	11	21	12	17	22	2	5	1	1					Good				53		1551											
R9-470718-00	645530	6	1	20	11	21	12	17	22	2	5	1	1					Good				53		1545											
R9-470719-00	645502	6	1	20	14	21	10	17	21	2	6	1	1					Good				56		1568											
R9-470720-00	645502	6	1	20	14	21	10	17	21	2	6	1	1					Good				56		1568											
R9-470721-00	645701	5	TR	19	11	15	12	17	23	3	8	1	1					Good				50		1558											
R9-470722-00	645701	5	TR	19	10	15	12	17	23	3	8	1	1					Good				50		1444											
R9-470723-00	645701	5	TR	19	11	15	12	17	23	3	8	1	1					Good				53		1558											
R9-470724-00	645701	5	TR	19	11	15	12	17	23	3	8	1	1					Good				53		1444											
R9-471202-00	645502	6	1	20	14	21	11	17	21	2	6	1	1					Good				57		1631											
R9-471203-00	645502	6	1	20	14	21	11	17	21	2	6	1	1					Good				57		1604											
R9-471204-00	645502	6	1	20	14	21	11	17	21	2	6	1	1					Good				58		1604											
R9-471205-00	645502	6	1	20	14	21	11	17	21	2	6	1	1					Good				58		1530											

0060 mat'l

06.23

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.65 ± 50 (F)=8"	PLASTIC STRAIN RATIO (R) (A)=r ₀ (C)=r ₄₅ (B)=r ₉₀ (D)=(r ₀ +r ₄₅ +2r ₄₅)/4	IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm (C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

Satish Misra
 QC METALLURGIST

FAKED

PO # 984